

Work Order ID 54223

December 3, 2009 1:03:21 PM

Page 1

Item ID: d3608-1F

Revision ID: ~~PB1~~ 1.04/12/09

Item Name: Lower Dobbler

Start Date: 12/03/09 Start Qty: 1.00

Required Date: 12/04/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

~~PB1~~ 1.04/12/04

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608
Deburr if necessary

Dwg Rev: PRE Prog Rev: LIM 2-

B 9-12-4

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

PB 9-12-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8 01/12/04

④

q

PRELIMINARY ISSUE
04.12.03



Cust Item ID:

Customer:



Work Order ID 54223

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Page 2

Item ID: d3608-1F
Revision ID: **P1B** 09/12/09
Item Name: Lower Doubler

Accept



Setup Start



Stop



Start Date: 12/03/09 Start Qty: 1.00
Required Date: 12/04/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:

Tooling:

Date:

Run Start



Stop



Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: Store

0.00



Packaging

Memo

8/12/14

(+1) 0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/10 *[Signature]*

u g 1208

POSITIVE RECALL

EFFECTIVE 10/1/08

AUTH [Signature]

RELEASED [Signature]

DATE 10.02.10

Picklist Print

December 3, 2009 1:03:20 PM

Work Order ID: 54223

Parent Item: d3608-1F

Parent Item Name: Lower Doubler

Comments:

Start Date: 12/03/09

Required Date: 12/04/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

307.9136

0.7781



304/316 .040 Sheet

B 9-12-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

307.9136158

110076

1.37053684

112567

38.0765789

112885

83.1578

113062

167.9323

113077

17.3764

113062

DART AEROSPACE LTD		Work Order:	54223
Description: Low F0 Double		Part Number:	D3608-1F
Inspection Dwg: D3608-1F Rev: PRELIM PBI		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+.004 - .001	.100	✓			
1.827	±.010	1.818	✓			
.500	±.010	.503	✓			
8.100	±.010	8.099	✓			
1.350	±.010	1.350	✓			
11.63	±.030	11.622	✓			
.250	±.010	.250	✓			
2.511	±.030	2.516	✓			
2.062	±.010	2.062	✓			
3.750	±.010	3.754	✓			
.750	±.010	.751	✓			
6.354	±.010	6.352	✓			
1.25	±.030	1.242	✓			
8.90	±.030	8.892	✓			
.400	±.010	.399	✓			
1.350	±.010	1.349	✓			
1.875	±.010	1.876	✓			
6.416	±.010	6.412	✓			
2.429	±.010	2.433	✓			
8.44	±.030	8.429	✓			
.040	±.010	.037	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-12-4	Date: 09/12/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

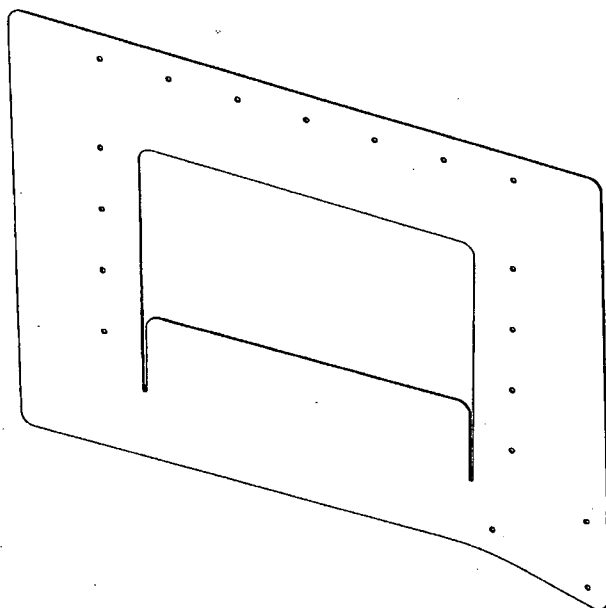
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D

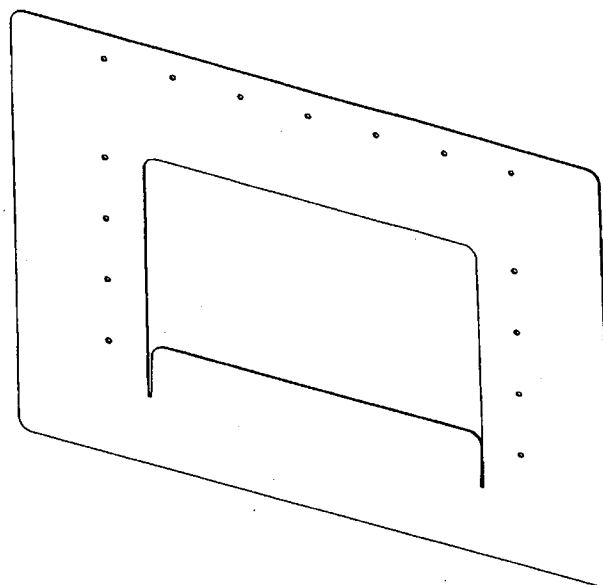
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B

A



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10

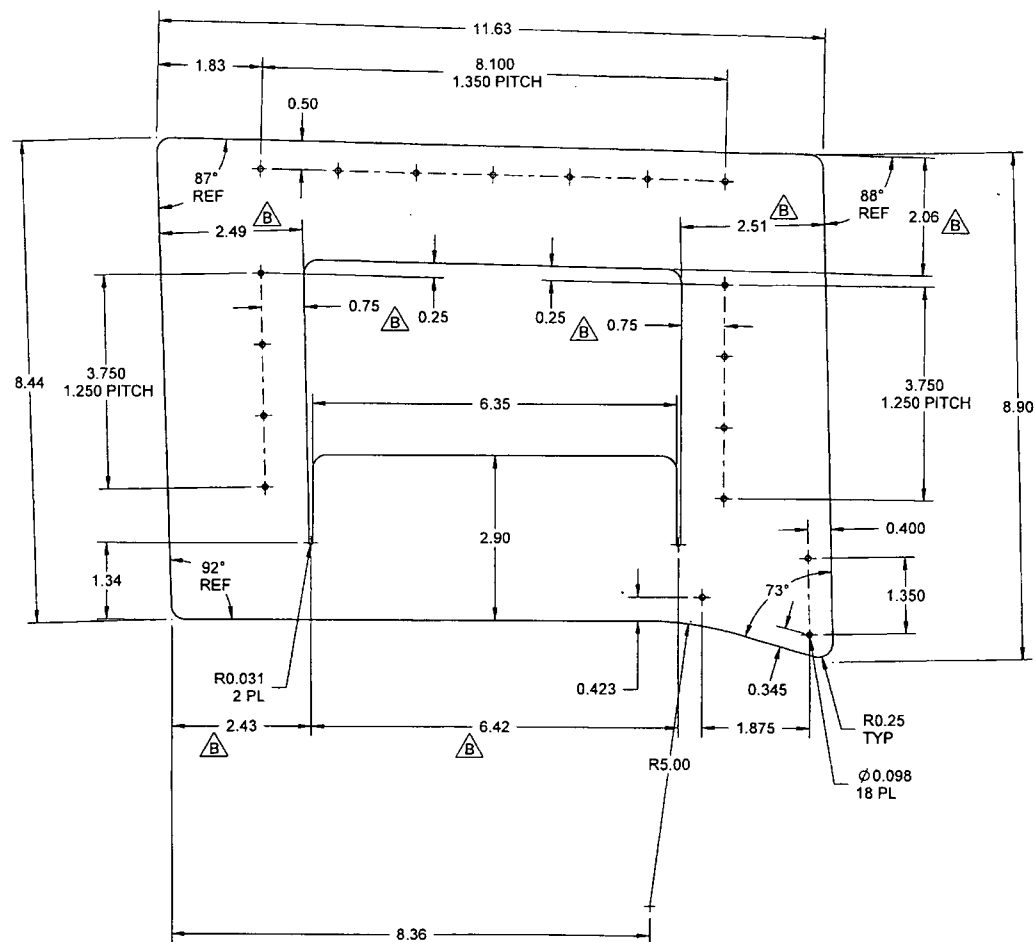
54223

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1F-3F; DELETED BENDING DETAILS. REASON: D3608-1-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.		MB	10.02.05
A	NEW ISSUE		MB	07.04.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO. REV. B	
APPROVED	DE APPR.		D3608 SHEET 1 OF 3	
DATE	10.02.05		TITLE DOUBLER SCALE NTS	
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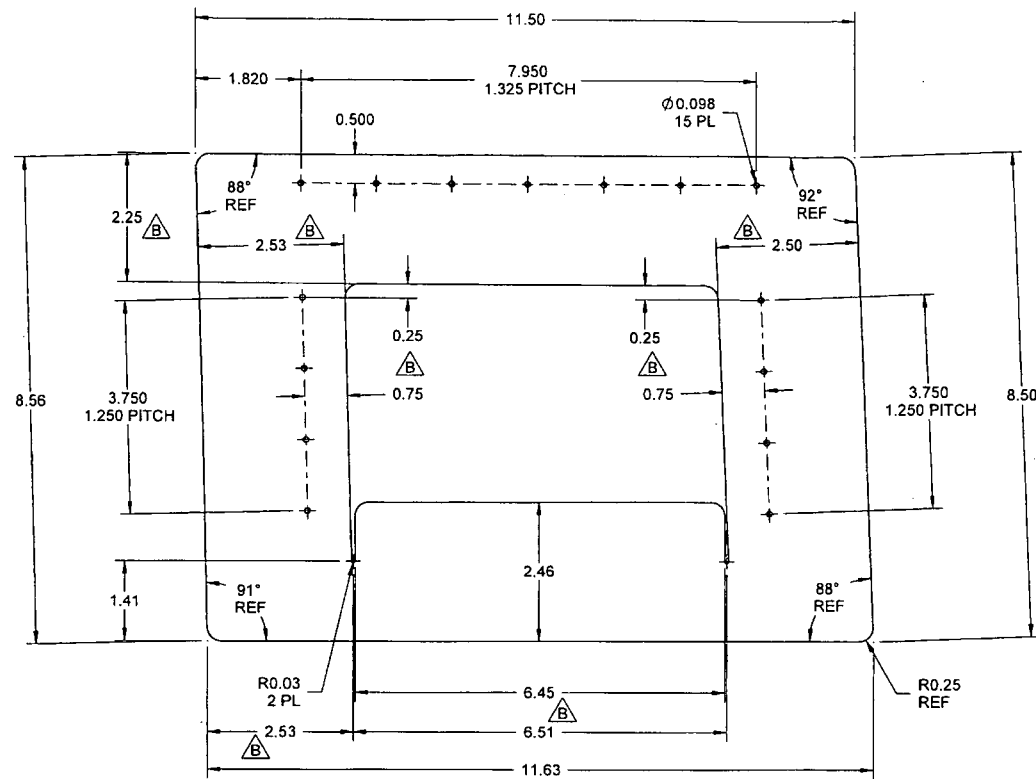


D3608-1 LOWER DOUBLER

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2010-02-10
ND

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D3608-3 UPPER DOUBLER

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2010-02-18

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